



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-8
Job Sheet 173283



Part No: SWA6A-8

Job Qty: 1 ea

Part Name: Electric Swivel 6,000 lb Safe Work Load (2,721 kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA6A Rev 4 IPP Rev A 18.02.06 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Small Fab-2		SR
110	Small Fab	1 pcs		3/16/18	0.00	2.00	Small Fab-6		DASAP
120	QC	1 pcs		3/16/18	0.00	0.00	QC5		38
125	DC	1 pcs		3/16/18	0.00	0.00	DC		9-80
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3		MAR 06 2018
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		MAR 12 2018

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** For 8 wire
Descriptions: strip outer jacket and replace with double layer heat shrink*** Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

125 - Photocopy blue file OM & OOPM-SWA6A Rev2

130 - Bag and tag

LOCTITE 242 → 138796 / PERMATEX 62040 → 138788 / SAF-T-EZE → M128 063

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	1 Ea (1 ea)	90-Start up Operation	5040151
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	110-Small Fab	5040240
30806	8 Wire	6 (6 ea)	110-Small Fab	5040207
C45-15-13	Sleeve	1 pcs (1 ea)	110-Small Fab	5029310
SWA6A-110	Lower End	1 Ea (1 ea)	110-Small Fab	5046042
SWA6A-1100	Upper Bearing	1 Ea (1 ea)	110-Small Fab	5040726
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5044605
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5043315
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	110-Small Fab	5045017
SWA6A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5040978
SWA6A-1900	Female Spade Terminal - 1/4"	12 Ea (12 ea)	110-Small Fab	5027243
SWA6A-2000	1/8" Female Spade Connector	4 Ea (4 ea)	110-Small Fab	5027244
SWA6A-210	Upper End	1 Ea (1 ea)	110-Small Fab	5046011
SWA6A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5040760
SWA6A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5035446
SWA6A-500	Semi Rings	1 Ea (1 ea)	110-Small Fab	5035127
SWA6A-600	Collar	1 Ea (1 ea)	110-Small Fab	5034731
SWA6A-700A	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5029418
SWA6A-900E	Rotary Contact	1 (1 ea)	110-Small Fab	5029580

YELLOW → BLACK / WHITE

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	1	21	0
110-Small Fab	188-FSCS-1032-5/8	4	184	0
	30806	6	0	0
	C45-15-13	1	0	0
	SWA6A-110	1	0	0
	SWA6A-1100	1	10	0
	SWA6A-1200	1	40	0
	SWA6A-1300	1	20	0
	SWA6A-1400	1	10	0
	SWA6A-1800	1	11	0
	SWA6A-1900	12	88	0
	SWA6A-2000	4	100	0
	SWA6A-210	1	1	0
	SWA6A-300	1	10	0
	SWA6A-400	1	10	0
	SWA6A-500	1	10	0
	SWA6A-600	1	10	0
	SWA6A-700A	2	0	0
	SWA6A-900E	1	0	0

Part Specifications

Specifications could not be found.



Container No: S046117



Part: SWA6A-8

Job No: 173283

Serial No/Batch: S046117

Revision: 4

Inspector:

Dart Aerospace Ltd.
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www.dartaerospace.com

1:40 PM Dart.lajeunesse.marie

Date: 02/27/10

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>SWA### Swivels</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Feb 01, 2018																		
Description Work Order Deviation				Disposition			Completed By																		
- Use a combination of heatshrink tubing and RTV Silicone to create a watertight seal around all electrical connections. - Use a D2728-1 Placard in place of the laser engraved Dart logo				These deviations are acceptable to carry out on the following swivels: - SWA3 - SWA6A - SWA10A - SWA15A - SWA25A - PSWA25A There is no impact on fit, form or function.			Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☒ Process Improvement ☒ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER : _____																							



Electric Swivel
SWA6A

Work Order 173283

Customer _____

Number of Wires 8

Date 2018/03/02

Serial Number S046117

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- PASS
1	6,000	Check all wires for grounding against swivel body.	- PASS
1	3,000	Check for Conductivity against all wires.	- PASS
1	3,000	Check all wires for grounding against swivel body.	- PASS
1	1,500	Check for Conductivity against all wires.	- PASS
1	1,500	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By: ALAIN PATRY

Technician

Submit

Signature: _____

Director of Quality Assurance